

Work Order ID 118920

May-23-14 10:11:59 AM

118920

Page 1

Item ID: D4930-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 5/05/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4930

B

0.00

105

105

Purchasing

Memo

0.00

Purchasing

ISSUE PO

24350

CUT BLANK AS PER FILE D4930-1 BLANK

CL 14/05/26 10

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

10X SP/4-6-10

118

QC6- Inspect dimensions to drawing

0.00

118

QC

Memo

0.00

Quality Control

5.406/15

X10

Work Order ID 118920

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Page 2

Item ID: D4930-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 5/05/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/05/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00

120

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FB218 and Dwg

FOLIO REV: AADWG REV: B

3-Deburr

10 0 14/06/15

130

0.00

130

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10 0 14/06/14

Work Order ID 118920

May-23-14 10:11:59 AM

118920

Page 3

Item ID: D4930-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearpaw
 Start Date: 5/05/14 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 5/05/14 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|-----------------------------------|----------------------|---------|----------|--------------|---------------|---------------|------------------|-------------------|
| 140 | QC8- Inspect parts - second check | 0.00 | | | | | | | DAS 08 9-89 |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | B.A | 14/06/16 | | 10 | 0 | | |
| Quality Control | | | | | | | | | |

| | | | | | | | | | |
|-----------|---|------|--|--|--|--|--|--|-------------------|
| 150 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | DAS 32 9-89 |
| *150* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

14/6/17
 ME
 14-6-16

| | | | |
|---------------------------|-------------|---------------------|--------|
| DART AEROSPACE LTD | | Work Order: | 118920 |
| Description: | | Part Number: | |
| Inspection Dwg: | Rev: | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|------------------|
| 0,07 | + 0,030 | 0,050 | ✓ | | MJP-04 | VUN |
| 5,50 | + 0,030 | 5,500 | ✓ | | ... | ... |
| R 0,25 | + 0,030 | 0,250 | ✓ | | — | Radius gauge |
| 0,25 | + 0,030 | 0,260 | ✓ | | MJP-04 | VUN |
| 0,63 | + 0,030 | 0,621 | ✓ | | ... | ... |
| 0,13 x 45° | + 0,030 | 0,125 | ✓ | | ↓ | ↓ |
| 0,345 | + 0,010 | 0,365 | ✓ | | ↓ | ↓ |
| 14,76 | + 0,030 | 14,760 | ✓ | | MJP-07 | Tape |
| 0,95 | + 0,030 | 0,943 | ✓ | | MJP-04 | VUN |
| 0,260 | + 0,001 | 0,260 | ✓ | | ... | ... |
| 0,88 | + 0,030 | 0,980 | ✓ | | ... | ... |
| 0,450 | + 0,030 | 0,440 | ✓ | | GA-08 | Dial depth gauge |
| 0,38 | + 0,030 | 0,377 | ✓ | | MJP-04 | VUN |
| 3,850 | + 0,010 | 3,850 | ✓ | | ... | ... |
| 1,083 | + 0,010 | 1,083 | ✓ | | ↓ | ↓ |
| 5,870 | + 0,010 | 5,870 | ✓ | | ↓ | ↓ |
| 4,250 | + 0,010 | 4,250 | ✓ | | ↓ | ↓ |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

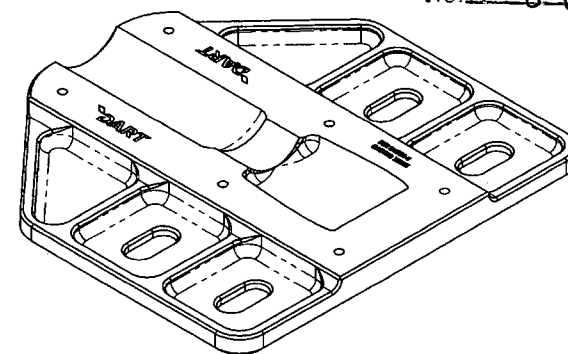
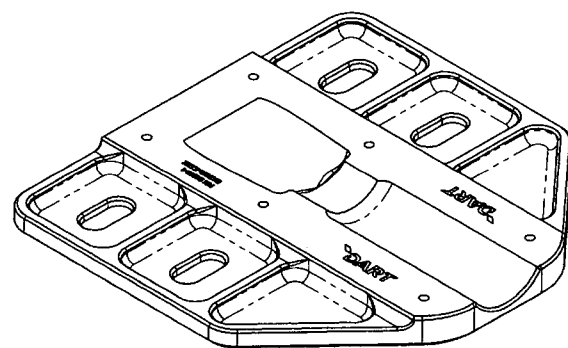
| | | | | | | |
|---------------------|--------------------|--------------------|--------------------|------------|------------------------------|--|
| Measured by: | <i>[Signature]</i> | Audited by: | <i>[Signature]</i> | DAS | Preliminary Approval: | |
| Date: | 14/04/14 | Date: | 14/06/16 | 08-9-89 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| E | 10.04.14 | Added preliminary approval | KJ | |

[Signature] 10.04.15

SHOP COPY
 RETURN TO
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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE

WORK ORDER
 NO. 118920 MCT
1405-07

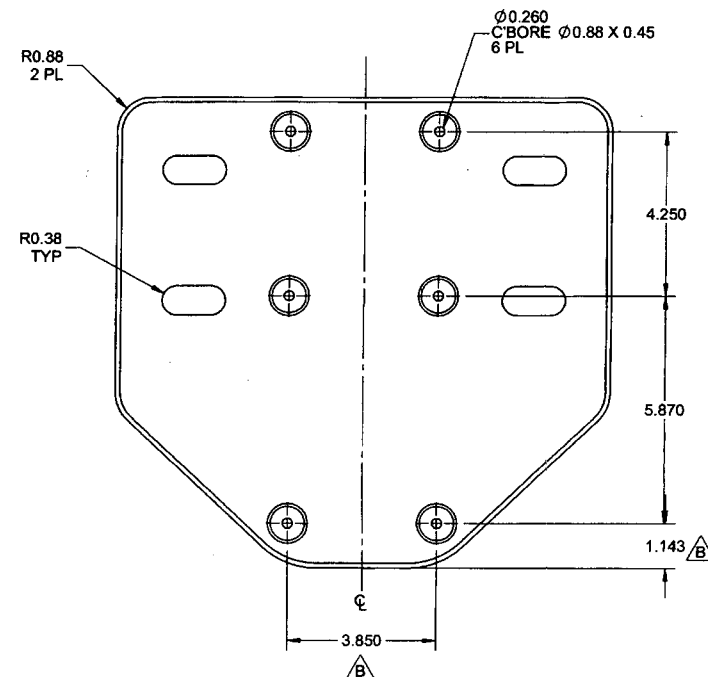
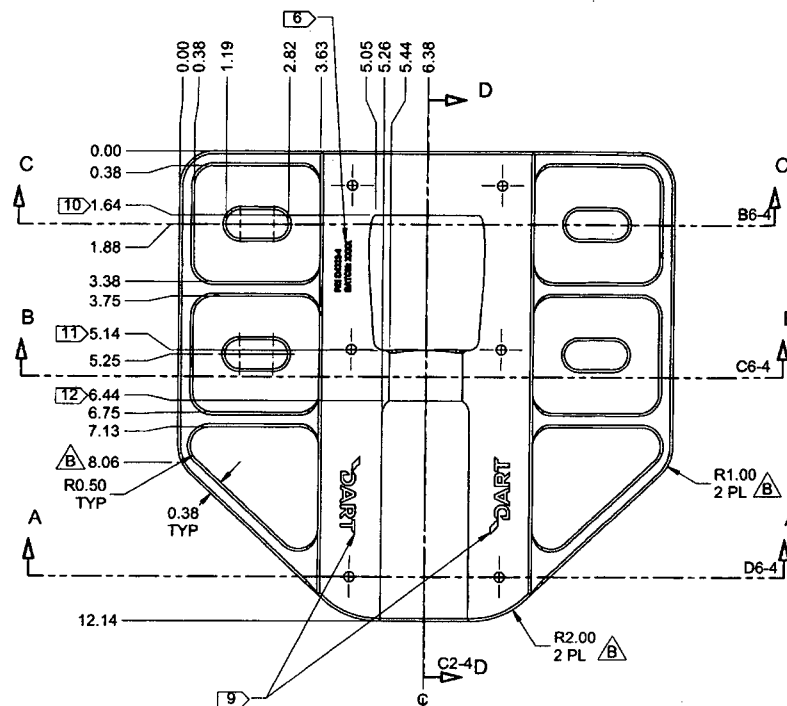


RELEASED
 2013-12-12
 [Signature]

D4930-1 BEARPAW

| | | | | |
|------------|--|--|----|----------|
| B | MOVE CLAMP HOLES @ 250" APART, ZN B2-3, B2-5, ADJUST TANGENT POINT, ZN C7-3, ADJUST RADIUS, ZN C5-3, B5-3, MOVE CLAMP HOLES AFT, ZN B1-3 | | VS | 13.12.05 |
| A | NEW ISSUE | | VS | 13.09.03 |
| REV. | | DESCRIPTION | BY | DATE |
| DESIGN | VS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4930 REV. B SHEET 1 OF 6 TITLE BEARPAW SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | | |
| DRAWN | VS | | | |
| CHECKED | HS | | | |
| MFG. APPR. | JLM | | | |
| APPROVED | HS | | | |
| DE APPR. | DS | | | |
| DATE | 13.12.10 | | | |

| | | | |
|------|--|----|----------|
| B | MOVE CLAMP HOLES 0.250" APART, ZN B2-3, B2-5, ADJUST TANGENT POINT, ZN C7-3, ADJUST RADIUS, ZN C5-3, B5-3, MOVE CLAMP HOLES AFT, ZN B1-3 | VS | 13.12.05 |
| A | NEW ISSUE | VS | 13.09.03 |
| REV. | DESCRIPTION | BY | DATE |



D4930-1 BEARPAW

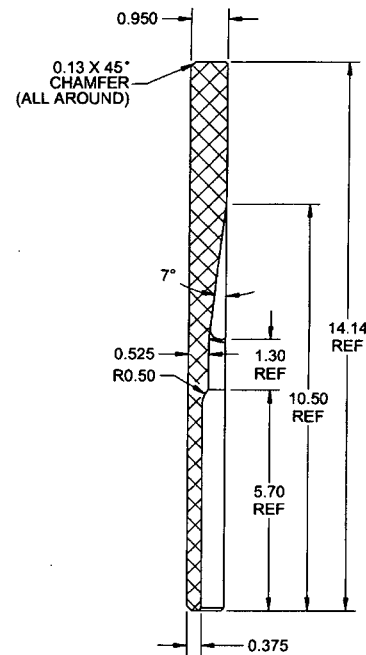
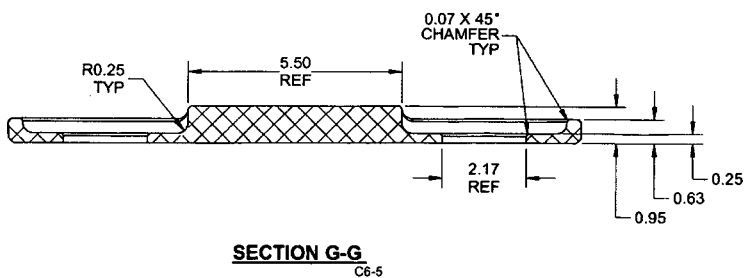
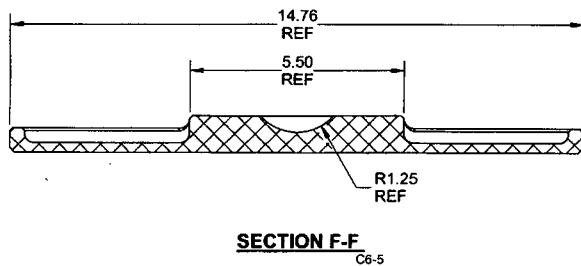
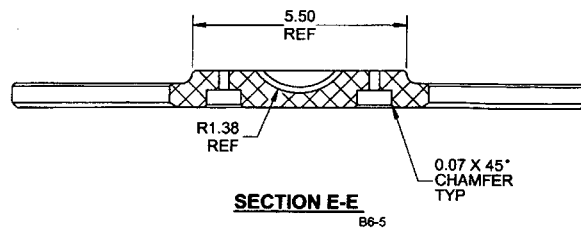
NOTES:

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMWB10
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 0.010-0.012 DP WITH
A MINIMUM 0.010 RAD
- 7) WEIGHT: 2.64 lbs
- 8) PART IS SYMMETRIC ABOUT C
- 9) ENGRAVE "DART" LOGO AS SHOWN 0.010 - 0.012 DP WITH A
MINIMUM 0.010 RAD
- 10) UNIFORM TAPER
- 11) MACHINE R1.25 BORE
- 12) MACHINE R1.38 BORE

RELEASED
2013-12-12

APPROVED

| | | | |
|------------|----------|---|--------------|
| DESIGN | VS | DART AEROSPACE LTD | |
| DRAWN | VS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | HS | DRAWING NO. | REV. B |
| MFG. APPR. | JLM | D4930 | SHEET 3 OF 6 |
| APPROVED | HS | TITLE | SCALE |
| DE APPR. | DS | BEARPAW | NTS |
| DATE | 13.12.10 | COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |



D4930-3 BEARPAW

APPROVED

| | | |
|------------|----------|---|
| DESIGN | VS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| DRAWN | VS | |
| CHECKED | HS | DRAWING NO. D4930 |
| MFG. APPR. | JLM | REV. B SHEET 6 OF 6 |
| APPROVED | HS | TITLE BEARPAW |
| DE APPR. | DS | SCALE NTS |
| DATE | 13.12.10 | COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD |

2013-12-12 L
70



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24350

Purchase Order Date 5/26/2014

PO Print Date 5/26/2014

Page Number 4 of 4

Order From :

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

VC-TPI001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450-633-0484

Ship To Contact

Ship To Phone

Ship Via:

Day & Ross collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

| | | | | | | | |
|----|--------|-----------------|-----------|------|---|---------|---------|
| 10 | 114239 | D4796-1 BEARPAW | 6/13/2014 | 8.00 | ✓ | \$44.64 | \$357.1 |
| | | | Yes | | | | |
| | | | 6/13/2014 | | | | |

CUT BLANK AS PER FILE

Line Total: \$357.1

| | | | | | | | |
|----|--------|-----------------|-----------|------|---|---------|---------|
| 11 | 114237 | D4930-1 BEARPAW | 6/13/2014 | 8.00 | ✓ | \$22.54 | \$180.3 |
| | | | Yes | | | | |
| | | | 6/13/2014 | | | | |

CUT BLANK AS PER FILE

Line Total: \$180.3

| | | | | | | | |
|----|--------|-----------------|-----------|-------|---|---------|---------|
| 12 | 118920 | D4930-3 BEARPAW | 6/13/2014 | 10.00 | ✓ | \$25.29 | \$252.8 |
| | | | Yes | | | | |
| | | | 6/13/2014 | | | | |

CUT BLANK AS PER FILE

Line Total: \$252.8

PO Total: \$3,252.3

SP14-6-10

W C L J

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr:

1

Change Date: 5/26/2014